

Date: Wednesday, 14/01/2009 10:22:44 AM  
 User: Julie Dawson

## Process Sheet

<b>Customer</b>	: CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b>	: RIB/ GUSSET ASSY
<b>Job Number</b>	: 44756		
<b>Estimate Number</b>	: 13651		
<b>P.O. Number</b>	:	<b>Part Number</b>	: D3826041
<b>This Issue</b>	: 14/01/2009	<b>S.O. No.</b>	:
<b>Prsht Rev.</b>	: NC	<b>Drawing Number</b>	: D3826 REV A
<b>First Issue</b>	: / /	<b>Project Number</b>	: N/A
<b>Previous Run</b>	: 44010	<b>Drawing Revision</b>	: A
	<b>Type</b> : LARGE FAB ASSY	<b>Material</b>	:
<b>Written By</b>	:	<b>Due Date</b>	: 21/01/2009
<b>Checked &amp; Approved By</b>	: <u>JD 09.01.14</u>	<b>Qty:</b>	4
<b>Comment</b>	: Est Rev:A 08-12-01 new issue DD verified by:EC	<b>Um:</b>	Each

## Additional Product

Job Number:



<b>Seq. #:</b>	<b>Machine Or Operation:</b>	<b>Description :</b>
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1.0	D22351	Basket Rib
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**Comment:** Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Basket Rib

batch: B44754

CP 09.01.21

2.0	D2325	Support Gusset (350 Basket)
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**Comment:** Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

Support Gusset (350 Basket)

batch: B43289

CP 09.01.21

3.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
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**Comment:** LARGE FABRICATION RESOURCE 1

1- use DT9434 to assemble D2325 support gusset together

2- locate D2325 on rib and weld as per dwg D3826

A/R ER316 S.S. Rod Batch: M106762

CP 09.01.21

(x4)

4.0	QC9	VISUAL WELDING INSPECTION
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**Comment:** VISUAL WELDING INSPECTION

PD 09.01.22 (4)

5.0	QC5	INSPECT WORK TO CURRENT STEP
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**Comment:** INSPECT WORK TO CURRENT STEP

09.01.22 (x4)

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Wednesday, 14/01/2009 10:22:44 AM  
User: Julie Dawson

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: RIB/ GUSSET ASSY

Job Number: 44756

Part Number: D3826041

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: Basket c.

PD 09.01-22

(9)

7.0

QC21

FINAL INSPECTION/W/O RELEASE



09/01/2009

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



09.01.22

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

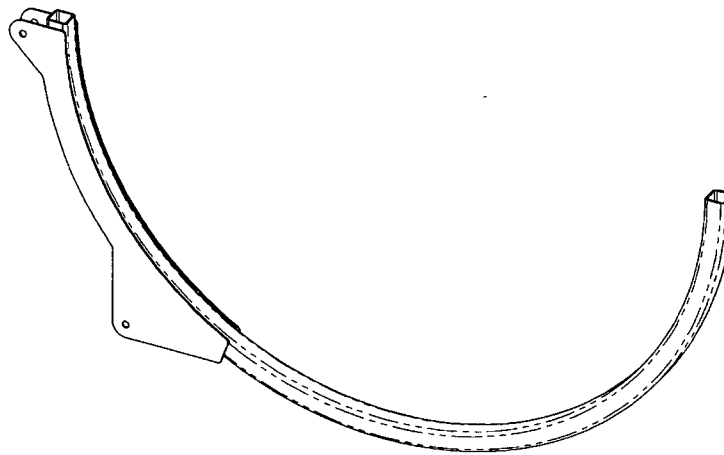
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

ITEM	QTY -041	P/N	DESCRIPTION
1	X	D3826-041	RIB/GUSSET ASSEMBLY
2	1	D2235-1	RIB
3	2	D2325	SUPPORT GUSSET



**D3826-041 RIB/GUSSET ASSY**

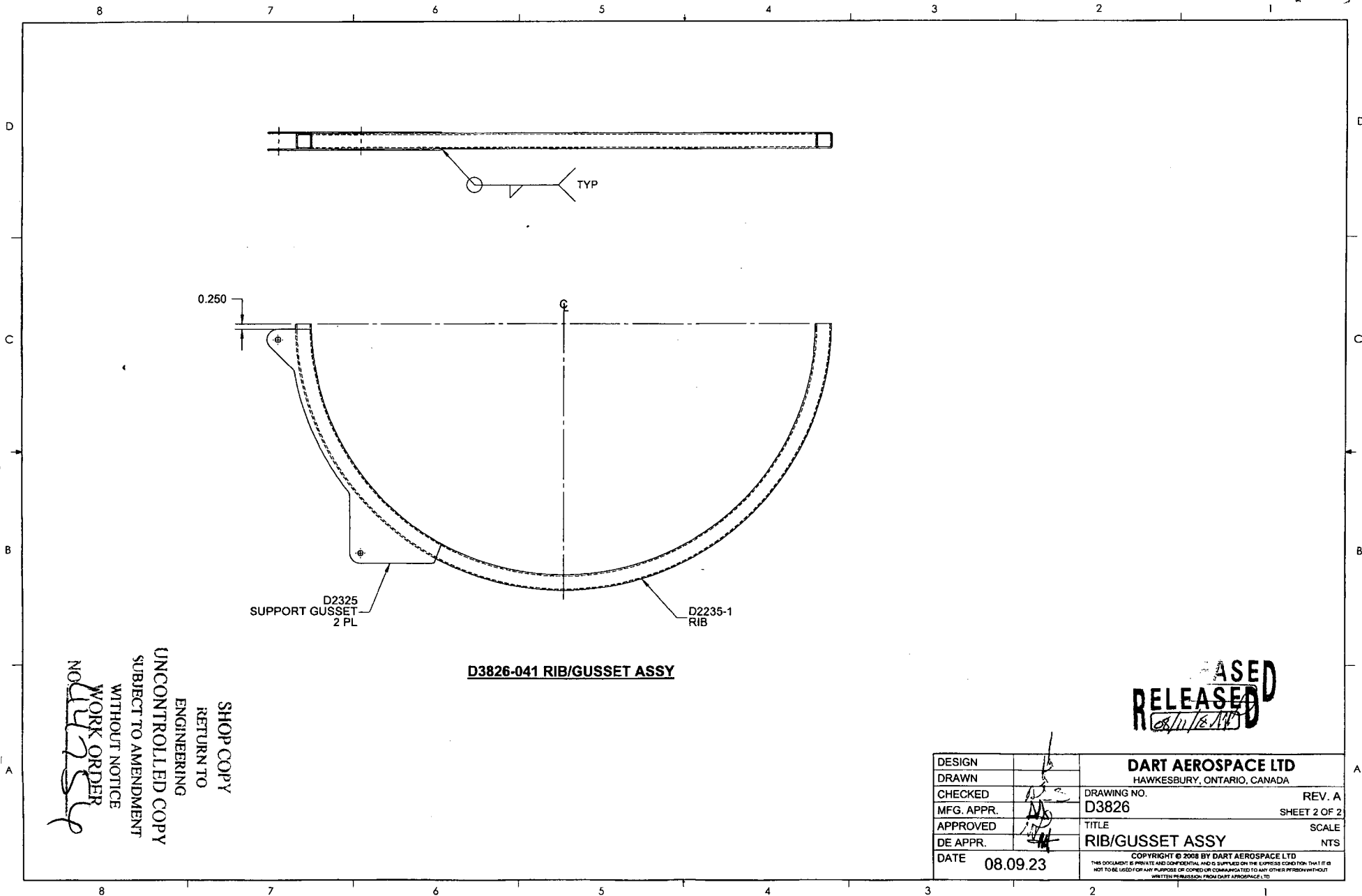
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WITHOUT NOTICE  
WORK ORDER  
NO. 44750

- NOTES:
- 1) MATERIAL: N/A
  - 2) FINISH: NONE
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: N/A
  - 7) WEIGHT: 2.59 lbs

**RELEASED**  
08/11/19

A	NEW ISSUE	MB	08.09.23
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	08.09.23		

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DRAWING NO. <b>D3826</b>	SHEET 1 OF 2	
TITLE <b>RIB/GUSSET ASSY</b>	SCALE NTS	
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**D3826-041 RIB/GUSSET ASSY**

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8/11/84

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CHECKED		DRAWING NO.	REV. A
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